

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020057**Date Inspected:** 18-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Hua Jie, Lu Li Qing, Geng Wei			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12BW, Deck plate (DP3057A) to Deck plate (DP3058A).

FCAW welding of weld joint SEG3005*-002; located on assembly, Bay 14, 12BW. Welder is identified as 201215; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

Assembly, Bay 14, 12AE, CA6501C.

During Random Visual in process Inspection, this QA inspector observed Crack like Indication at temporary attachment area on side plate (SP3016A) of Corner assembly (CA6501C). This QA inspector confirmed the indication with Magnetic Particle Inspection (MT) & also informed ZPMC QC "Geng Wei". The attached photographs provide additional detail.

Assembly, Bay 14, 12AE, CA6501C.

FCAW welding of weld joint CA6501C-023, 027, 031; located on assembly, Bay 14, 12AE. Welder is identified as 044795; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

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Assembly, Bay 14, 12AE, CA3001.

FCAW welding of weld joint CA3001-003; located on assembly, Bay 14, 12AE. Welder is identified as 058551, 044774; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1) WPS-B-T-2231-TC-U4B-F, 2) WPS-B-T-2231-TC-U4C-F.

Assembly, Bay 14, 11DE, SEG072.

SMAW welding of weld joint SSD18-PP106-0129; located on assembly, Bay 14, 11DE. Welder is identified as 067904; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4B-FCM-1.

Assembly, Bay 14, 12CE.

During Random Visual in process Inspection, this QA inspector observed fit-up of Edge plate EP3003A of Corner Assembly CA3004E. The attached photographs provide additional detail.

Training for Phased Array Ultrasonic Testing.

This QA inspector attended Training for Phased Array Ultrasonic Testing (PAUT) from 1600Hrs. to 1900Hrs.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit
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Quality Assurance Inspector

Reviewed By:	Miller,Mark
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QA Reviewer
